

Work Order ID 60425

Wednesday, July 07, 2010 1:17:31 PM



Page 1

Item ID: D2583

Accept



Setup Start



Revision ID:

Item Name: Latch Bracket

Stop



Start Date: 7/7/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/21/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-7-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D2583

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D2583 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

ml 10 07 15 (12)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

ml 10 07 15 (12)

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/10

(112)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr Form on CNC Brake as per Dwg D2583

SB 10/07/21

(12)

Deburr 27m-1 10/07/14

(12x)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10.07.21

(42)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

12 BR 10-7-21

W/O:		WORK ORDER CHANGES					
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Revision ID:

Item Name: Latch Bracket

Start Date: 7/7/2010 Start Qty: 12.00

Required Date: 7/21/2010 Req'd Qty: 12.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

Memo

0.00

START TIME:

3:25

COVEN TEMPERATURE:

3:22 FINISH TIME:

3:55

12 BR 10-7-21

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/07/22

12 4

180



Packaging

Packaging

Identify as per dwg & Stock Location

17

0.00

Memo

0.00

10.7.22

124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Stop



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Cust Item ID:

Required Date: 7/21/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/23

MF

10-7-22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 07, 2010 1:17:30 PM

Page 1

Work Order ID: 60425

Parent Item: D2583

Parent Item Name: Latch Bracket



Start Date: 7/7/2010

Required Date: 7/21/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat- in house process□DM□
IPP: D□06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	79.0000	0.1169	1.476632			

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT

64

114488

64

MAT23

15

101875

1.5

109058

10

113123

3.5

M 10-07-15

W/O:		WORK ORDER CHANGES					
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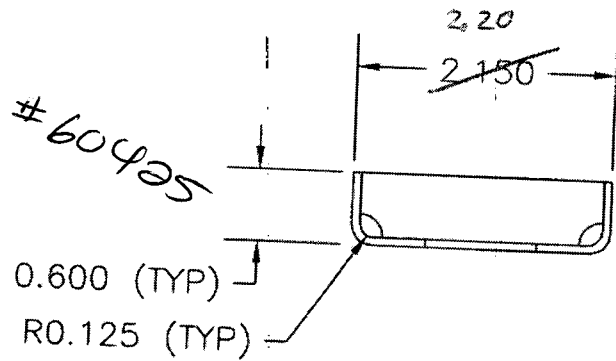
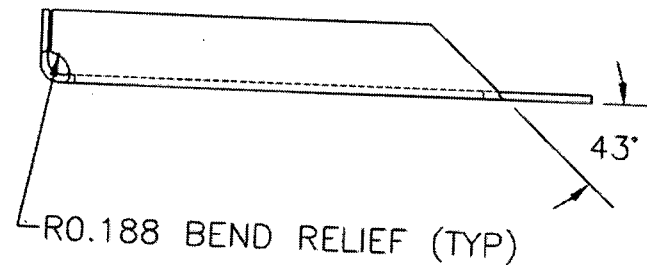
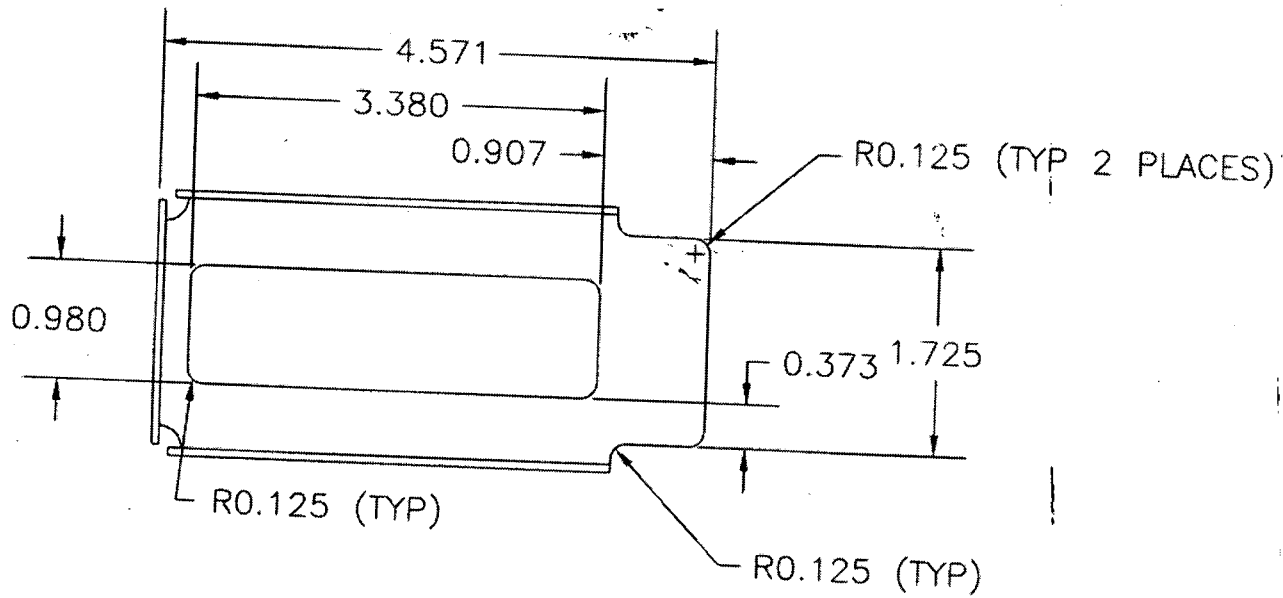
NOTE: Date & initial all entries

DART



RELEASED
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RE	DART AEROSPACE LTD
CHECKED	CP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	TITLE	D2583	REV. B
			LATCH BRACKET	SHEET 1 OF 1
A	96.07.10	NEW ISSUE		SCALE 2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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